

Date:
User:Wednesday, 3/12/2008 1:51:25 PM
Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : BAR
Job Number : 37885	
Estimate Number : 10390	
P.O. Number :	Part Number : D3197041
This Issue : 3/12/2008 S.O. No. :	Drawing Number : D3197 REV B
Prsht Rev. : NC	Project Number : N/A
First Issue : 1/1 Type : MACHINED PARTS	Drawing Revision : B
Previous Run : 35281	Material :
Written By :	Due Date : 3/28/2008 Qty: 12 Um: Each
Checked & Approved By : <u>H 08 03 12</u>	
Comment : Est Rev: A New Issue 05-11-08 JLM	
Est Rev: B As per Rev B 06-03-10 JLM	

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M7075T73R1000 7075-T73 Round Bar 1" OD



Comment: Qty.: 2.5410 f(s)/Unit Total: 30.4920 f(s)
 Material: 7075-T73 (QQ-A-200/11) or (QQ-A-225/9) 1" OD
 (M7075T73R1.000)
 Identify for D3197-1
 Batch: M107513 1106070 10.4f
20.8f 080401

2.0 BAND SAW BAND SAW



Comment: BAND SAW
 Cut blanks: 29.125" long

08040112

3.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1
 1-Face ends to length per dwg D3197

Machined Manually 080401 12

2-Machine D3197-1 as per Folio FA340 and Dwg D3197

3-Deburr

SA 08104/11(12)

4.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SA 08104/11(12)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

LATHE CONV.

CONVENTIONAL LATHE



Comment: CONVENTIONAL LATHE
Chamfer as per Dwg D3197

SA 08/04/11

(13)

6.0

QC8

SECOND CHECK



Comment: SECOND CHECK

SA 08/04/11 (12)

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1
Chemical Conversion Coat as per QSI 005 4.1

SA 08-04-14

(13)

8.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING
Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

m 106442

FL 08/04/15

(12)

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

ml 08/04/15

10.0

D26905

Lanyard ass'y



Comment: Qty.: 2.0000 Each(s)/Unit Total: 24.0000 Each(s)
Pick:

Qty Part Number Description Batch
2 D2690-5 Lanyard 37937 30611

PC

11.0

D32421

Tag



Comment: Qty.: 2.0000 Each(s)/Unit Total: 24.0000 Each(s)
Pick:

Qty Part Number Description Batch
2 D3242-1 TAG 1335311

6x 137937 18x 8/4/15 (12)

W/O:		WORK ORDER CHANGES					
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QA: N/C Closed: _____ Date: _____

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Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

AN960JD10

Washer



Comment: Qty.: 6.0000 Each(s)/Unit Total : 72.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

6 AN960JD10

Washer

M167534

[Signature]

13.0

D34893200

PIP PIN



Comment: Qty.: 2.0000 Each(s)/Unit Total : 24.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

2 D3489-3-200

Pip Pin

35313 13X B 37937 11X

[Signature]

14.0

MS21042L3

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 24.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

2 MS21042L3

Nut (or -3)

M106883

[Signature]

15.0

MS27039124

Screw



Comment: Qty.: 2.0000 Each(s)/Unit Total : 24.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

2 MS27039-1-24 Screw

M100274 11X M10051 13X

[Signature] 8/4/10 (12)

16.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1
Assemble D3197-041 as per Dwg D3197

[Signature] mil 08/04/15

[Signature] XL2

17.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

[Signature] 08-04-16 (12)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Machine Or Operation:

Description :

18.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

ST 247

AS 08/04/16 (12)

19.0

QC21

FINAL INSPECTION/W/O RELEASE



08/04/17

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-04-16

W/O:		WORK ORDER CHANGES					
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NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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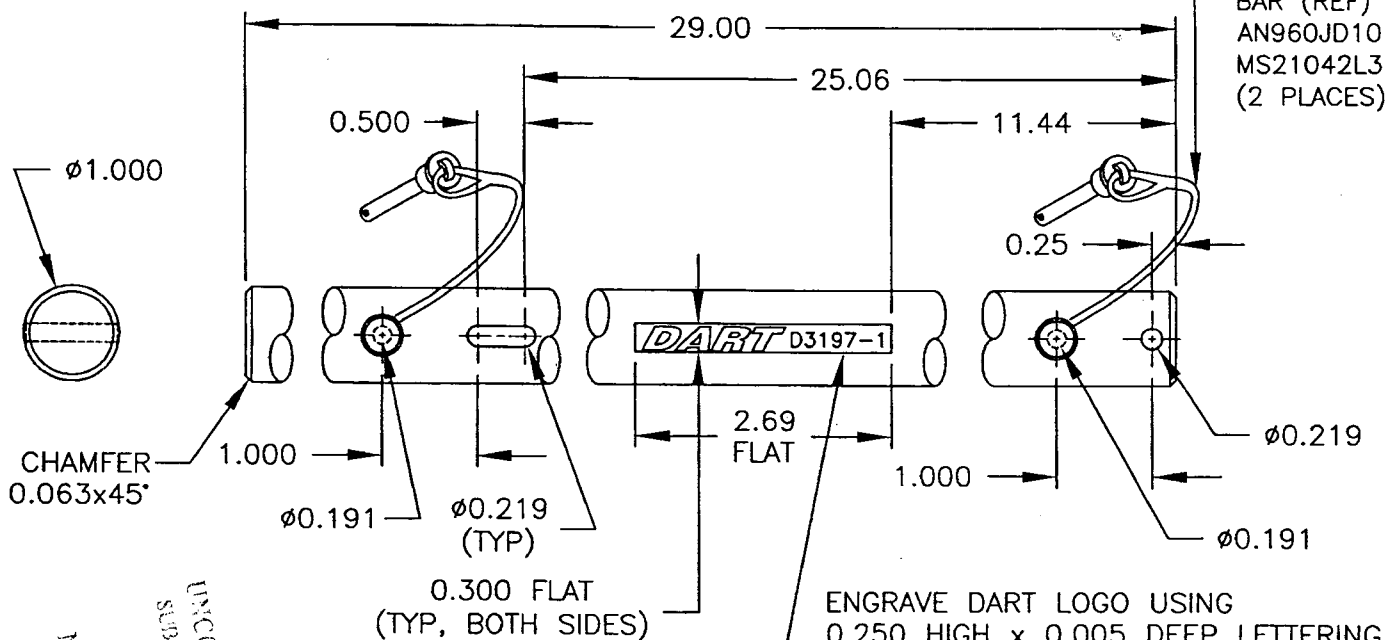
NOTE: Date & initial all entries

RELEASED

06.03.10
per EON 32

D3489-3-200 PIP PIN (1)
D3242-1 TAG (1)
MS27039-1-24 BOLT (1)
AN960JD10 WASHER (1)
D2690-5 LANYARD (1)
AN960JD10 WASHER (1)
BAR (REF)
AN960JD10 WASHER (1)
MS21042L3 NUT (1)
(2 PLACES)

DART



D3197-041 BAR ASSEMBLY

ENGRAVE DART LOGO USING
0.250 HIGH x 0.005 DEEP LETTERING
AND P/N USING 0.150 HIGH x 0.005
DEEP LETTERING ON BOTH SIDES

UNCONTROLLED COPY
ENGINEERING
RETURN TO
SHOP COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
DATE 06.01.10
BY 57885

D3197-1 BAR

- 1) MATERIAL: 7075-T73 ROUND BAR (QQ-A-200/11 or QQ-A-225/9) ϕ 1.000 O.D.
(REF DART SPEC. M7075T73R1.000)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) FOR TOOLING, IT IS ACCEPTABLE TO HAVE A 0.06 DEEP x 60° CENTER MARK AT EITHER
END OF THE BAR

DESIGN	CP	DRAWN BY	CP	DART AEROSPACE LTD
CHECKED		APPROVED		HAWKESBURY, ONTARIO, CANADA
DATE	06.01.10	TITLE	BAR	REV. B
				SHEET 1 OF 1
				SCALE 1:1
A	03.07.01	NEW ISSUE		
B	06.01.10	CHG PIP PIN; ADD D3242-1 TAG		

FIRST ARTICLE INSPECTION CHECKLIST

☐ First Article ☐ Prototype

[illegible]

Measured by:	SD
Date:	08/04/11

Audited by:	LF
Date:	08/04/11

Prototype Approval:	
Date:	

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/RF	